Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5702-1

Job Sheet 192317

80

Part No: D5702-1 **Job Qty:** ~~60~~ pcs

Part Name: Shim

DAS
21
9-89

Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 3/21/19 **Job Tracking No:**

Due Date: 4/12/19 **Created By:** Marie Lajeunesse

Type: ~~Stock~~ SAMPLE **Description:**

Note: D5702-1 REV.A IPR REV:A NEW ISSUE 18/11/09 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	**HAAS 4 Axis**	60 pcs		4/12/19	0.50	8.57	HAAS - 1		
							HAAS - 2		19/04/02
							HAAS - 3		
							HAAS - 4		
110	**QC 2**	60 pcs		4/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		19/04/02
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

DART AEROSPACE

Container No: S169002

Part: D5702 – 1
Job No: 192317
Serial No/Batch: S169002
Revision: A
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/02/19

					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
120	**QC 8**	60 pcs	4/12/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - ~~28~~ 23	VH 19/4/6
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
130	**Handfinish - 1-1 Chemical-B4B**	60 pcs	4/12/19	0.00 1.50	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/04/09
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 -	

					B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	**QC 7**	60 pcs	4/12/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	BK 19-04-10.
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
150	**Powdercoat - 1 White GI(A)-B4B**	60 pcs	4/12/19	0.00 0.00	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-04-10.
					Powdercoat - 4 - B4B	
160	**QC 3**	60 pcs	4/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	DAS
					QC 3 - 40	APR 11 2019 40
					QC 3 - 19	9-89

170 **Packaging 3-1 - Stock - B4B**	60 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	DAS
				Packaging 3 - 4 - B4B	28
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	DAS
180 **QC 21 - SA**	60 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	27
				QC 21 - SA - 70	9-89 APR 1 2 2019
				QC 21 - SA - 53	

Part Op Descriptions: **100** - 1- Cut blank at 3.000" long. 2-Machine per folio FC482 DWG REV:_____ FOLIO REV:_____ 3- Deburr and break all sharp edges.

150 - ***MASK HOLES PRIOR TO POWDER COAT AS PER DWG NOTE 9*** START TIME: 2:10 OVEN TEMPERATURE: 500° FINISH TIME: 2:40 M131749.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.000	6061-T6 Bar .500 X 2.00	15 ft (.25 ea)	100-HAAS 4 Axis	S098047 = 12.87 S008430 = 8.17

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	M6061T6B0.500X02.000	15	27	0

Part Specifications

Specifications could not be found.

Plex 3/21/19 9:26 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	192317
Description:	Shim	Part Number:	D5702-1
Inspection Dwg:	D5702 Rev: A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.410	±.010	.4085	✓		Vernier	
& .508 ×2	+.005/-.001	.510	✓		Gage pin	
1.72	±.030	1.719	✓		Vernier	
1.67	±.030	1.67	✓		↓	
2.87	±.030	2.864	✓			
2.5	±.030	2.498	✓			
2.75	±.030	2.749	✓			
2.83	±.030	2.829	✓			
.080	±.010	.080	✓			
.715	±.01	.715	✓			
97° Asdo	± ½°	96.5°	✓		angle Finder	CNC 17

Measured by:	Miguel Sanchez	Checked by:	[illegible]	QC Inspector:	
Date:	19/07/01	Date:	19/7/11	Date:	

Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled

☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up

☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: